



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-3
Job Sheet 178808



Part No: SWA25A-3

Job Qty: 1 ea

Part Name: Electric Swivel 25,000 lb Safe Work Load (11,340 kg)



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/25/18	0.00	0.00	Start Up Small Fab-4		18-06-11 03
110	Small Fab	1 pcs		6/25/18	0.00	2.00	Small Fab-9		A.P
120	QC	1 pcs		6/25/18	0.00	0.00	QC5		SB
125	DC	1 pcs		6/25/18	0.00	0.00	DC		SB 68-6
130	Packaging	1 pcs		6/25/18	0.00	0.00	Packaging3		JRB 8Z
140	QC21-FG	1 Ea		6/25/18	0.00	0.00	QC21		JUN 29 2018 SVC

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA25A swivel manual*** Engrave Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

125 - Photocopy blue file OM & OOPM-SWA25A Rev2

130 - Bag and tag

GREASE AEROSHELL No. 7 (M138724) LOCTITE 242 (M138762) SILICONE GE (M138883)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	5037083
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	110-Small Fab	5062757
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5058761
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5054451
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	5047767
SWA10A-1100	Upper DU Bearing	1 Ea (1 ea)	110-Small Fab	5060879
SWA10A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5079716
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5066607
SWA10A-1400	Circlip	1 Ea (1 ea)	110-Small Fab	5047197
SWA10A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5084519
SWA10A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5034295
SWA10A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5049940
SWA10A-500	Semi-Rings	1 Ea (1 ea)	110-Small Fab	5068691
SWA10A-600	Collar	1 Ea (1 ea)	110-Small Fab	5034519
SWA10A-700	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5038666
SWA25A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5082250
SWA25A-200	Upper End Swivel	1 Ea (1 ea)	110-Small Fab	5081510
SWA6A-1900	Female Spade Terminal - 1/4"	6 Ea (6 ea)	110-Small Fab	5054299
SWA6A-800B	Connector Bushing	1 Ea (1 ea)	110-Small Fab	5029400
SWA6A-900B	Rotary Contact	1 Ea (1 ea)	110-Small Fab	5072691

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
<table style="width:100%; border: none;"> <tr> <td colspan="2" style="text-align: center; border-bottom: 1px solid black;">Root Cause</td> <td colspan="3" style="text-align: center; border-bottom: 1px solid black;">FAULT CATEGORY</td> </tr> <tr> <td style="width:15%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:15%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:15%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:15%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:15%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:15%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> <tr> <td colspan="4" style="border: none;"> OTHER : ☐ </td> </tr> </table>					Root Cause		FAULT CATEGORY			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐					
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OTHER : ☐																					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-5/8	1	375	0
	188-FSCS-1032-5/8	4	489	0
110-Small Fab	EL-PLUG-F	1	39	0
	EL-PLUG-M	1	76	0
	EL314-SJTOW	6	917	0
	SWA10A-1100	1	7	0
	SWA10A-1200	1	28	0
	SWA10A-1300	1	37	0
	SWA10A-1400	1	37	0
	SWA10A-1800	1	3	0
	SWA10A-300	1	3	0
	SWA10A-400	1	5	0
	SWA10A-500	1	38	0
	SWA10A-600	1	5	0
	SWA10A-700	2	15	0
	SWA25A-100	1	0	0
	SWA25A-200	1	0	0
	SWA6A-1900	6	274	0
	SWA6A-800B	1	0	0
	SWA6A-900B	1	12	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 2:39 PM dart.lajeunesse.marie



Container No: S079558



Part: SWA25A-3

Job No: 178808

Serial No/Batch: S079558

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 819 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/11/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Work Order 178808

Customer _____

Number of Wires 3Date 2018/06/29Serial Number S079558

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	25,000	Check for Conductivity against all wires.	- PASS
1	25,000	Check all wires for grounding against swivel body.	- PASS
1	12,500	Check for Conductivity against all wires.	- PASS
1	12,500	Check all wires for grounding against swivel body.	- PASS
1	6,250	Check for Conductivity against all wires.	- PASS
1	6,250	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By: ALAIN PATRY

Technician

Signature: Sylvie Boucher

QC 5 Small FAB / QA

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

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Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
REPLACE P/N: SWA10A-700 WIRE CLAMP WITH P/N: SW10A-700A				THE SW10A-700A CLAMP PROVIDES A SUPERIOR CLAMP ON THE WIRE WITHOUT DAMAGING THE WIRE. THIS DEVIATION IS ACCEPTABLE																					
				Completed By <u>A. PATRY</u> Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					

Root Cause			FAULT CATEGORY					
Environment ☐	Design ☒	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Doc/Data ☐	Equip/Tooling ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Handling/Pre ☐	Material ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under toleran ☐		
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		Manufacturing Process ☐	OTHER :					
		Past Due ☐						